

**Work Order ID 61089**

Page 1

August 5, 2010 1:56:26 PM

Item ID: D4048-6

Accept



Setup

Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D4048	A

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.330" LONG

0.00

20/08/14

Y P

110



HAAS I

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA897

DWG REV: A

FOLIO REV: AA

0.00

20/08/16

Y P

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61089**

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Page 2

Item ID: D4048-6

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Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

arL 10/08/16

4 0

QC

Quality Control

130



QC8- Inspect parts - second check

0.00

B.A 10/08/16

4 0

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

10 08 17 (4)

HandFinish

Hand Finishing

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Work Order ID 61089

August 5, 2010 1:56:27 PM



Page 3

Item ID: D4048-6

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

=) 4

10 10 81 17

4

0

Powder Coating

Memo  
 \*\*\*Mask 0.257" holes and indicated channel prior to powder coat\*\*\*  
 POWDER COAT:  
 Start Time: 9:00 AM  
 Oven Temperature: 370 °F  
 Finish Time: 9:30 AM

160



QC3- Inspect Part Finish

0.00

10 08 17 4

Quality Control

Memo

0.00

170



Identify as per dwg &amp; Stock Location: ST120 0.00

0.00

X4 BB 10/08/17

Packaging

Packaging

Memo

0.00

1 to add to D205-S41-142 Basket  
 see w/o 61090

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61089**

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Page 4

Item ID: D4048-6

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Revision ID:

Item Name: Mounting Lug

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Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

QC  
Quality Control

Memo

10/08/19 JG

MF  
10-8-18

# Picklist Print

August 5, 2010 1:56:25 PM

Page 1

Work Order ID: 61089



Parent Item: D4048-6



Parent Item Name: Mounting Lug

Start Date: 8/05/10

Required Date: 8/13/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE JLM 10-01-26 VERIFIED BY:EC IPP  
Rev:B as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X04.00 0		Purchased		No		100	f	11.2643	0.44441	1.8712			

6061T6 Bar 1.500 x 4.00



Location	Loc Qty	Loc Code
MAT09	11.2643	
113797	11.2643	

1.8712  
MK  
20/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	61089
<b>Description:</b> Mounting Lug	<b>Part Number:</b>	D4048-6
Inspection Dwg: D4048	Rev: A	Page 1 of 1

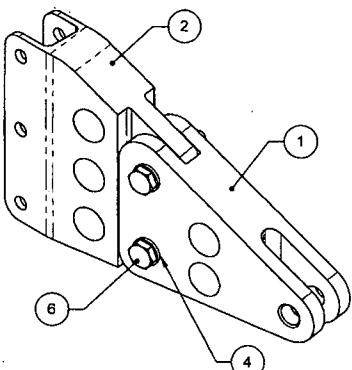
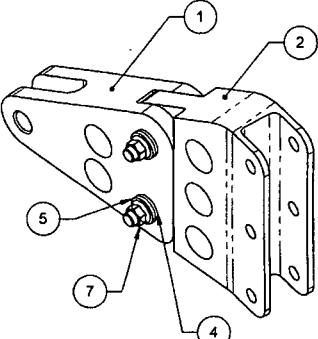
## **FIRST ARTICLE INSPECTION CHECKLIST**

Measured by:	<u>Amy</u>
Date:	10/08/16

Audited by:	b.A
Date:	10/08/16

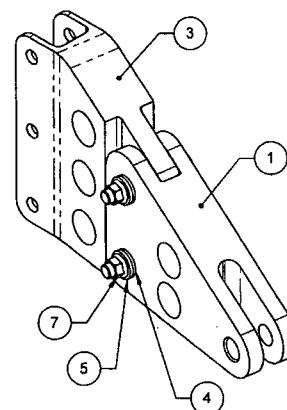
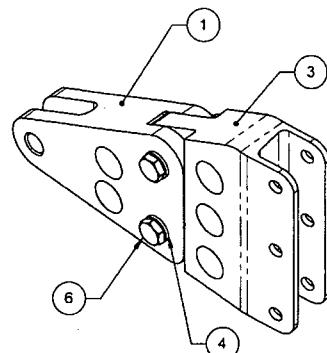
<b>Preliminary Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	 



**D4048-041 MOUNTING LUG ASSY (SHOWN)**

**NOTES:**  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS O  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "I  
7) WEIGHT: D4048-041-042: 1.16 lbs  
8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 N



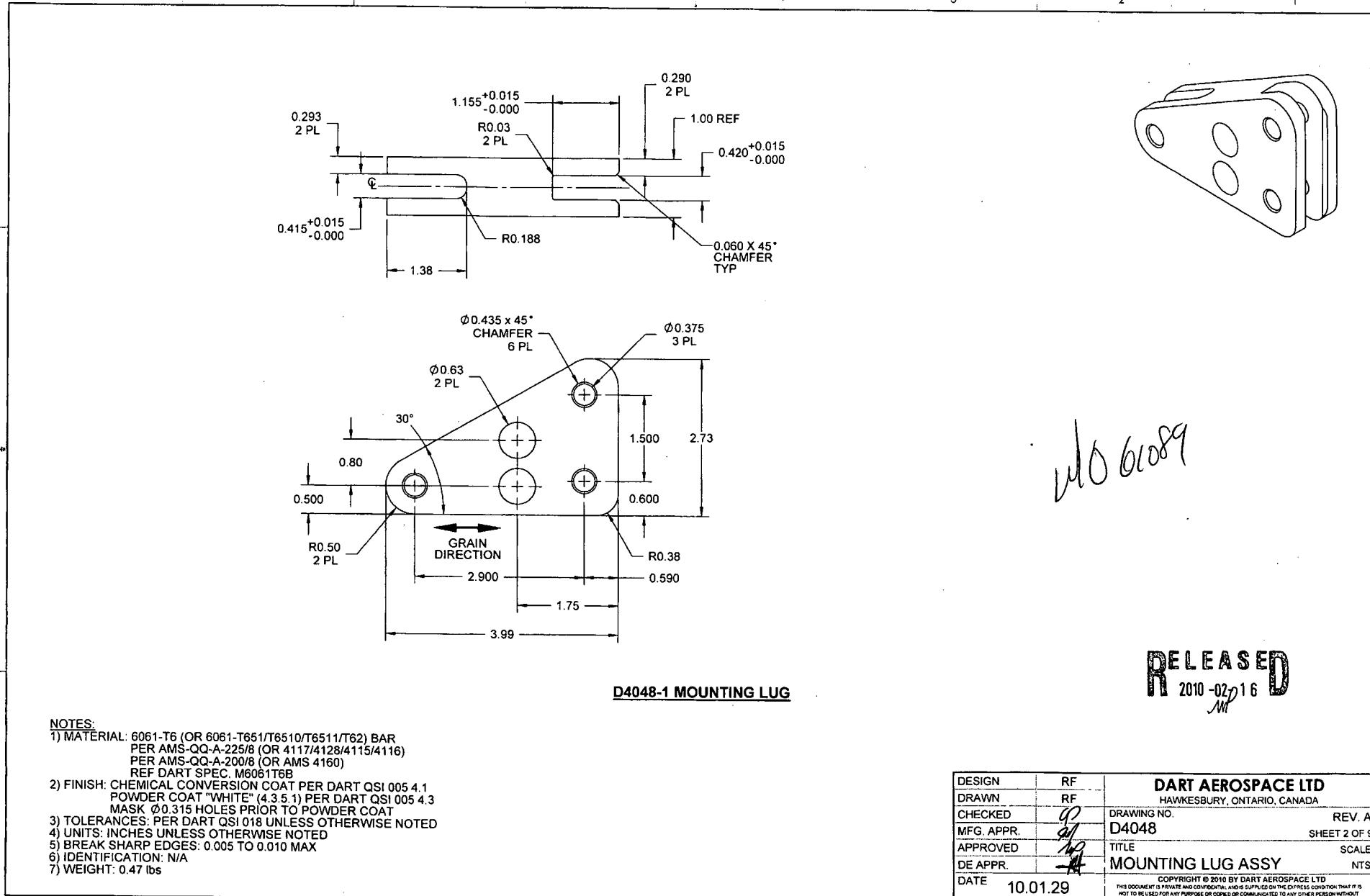
**D4048-042 MOUNTING LUG ASSY (SHOWN)**

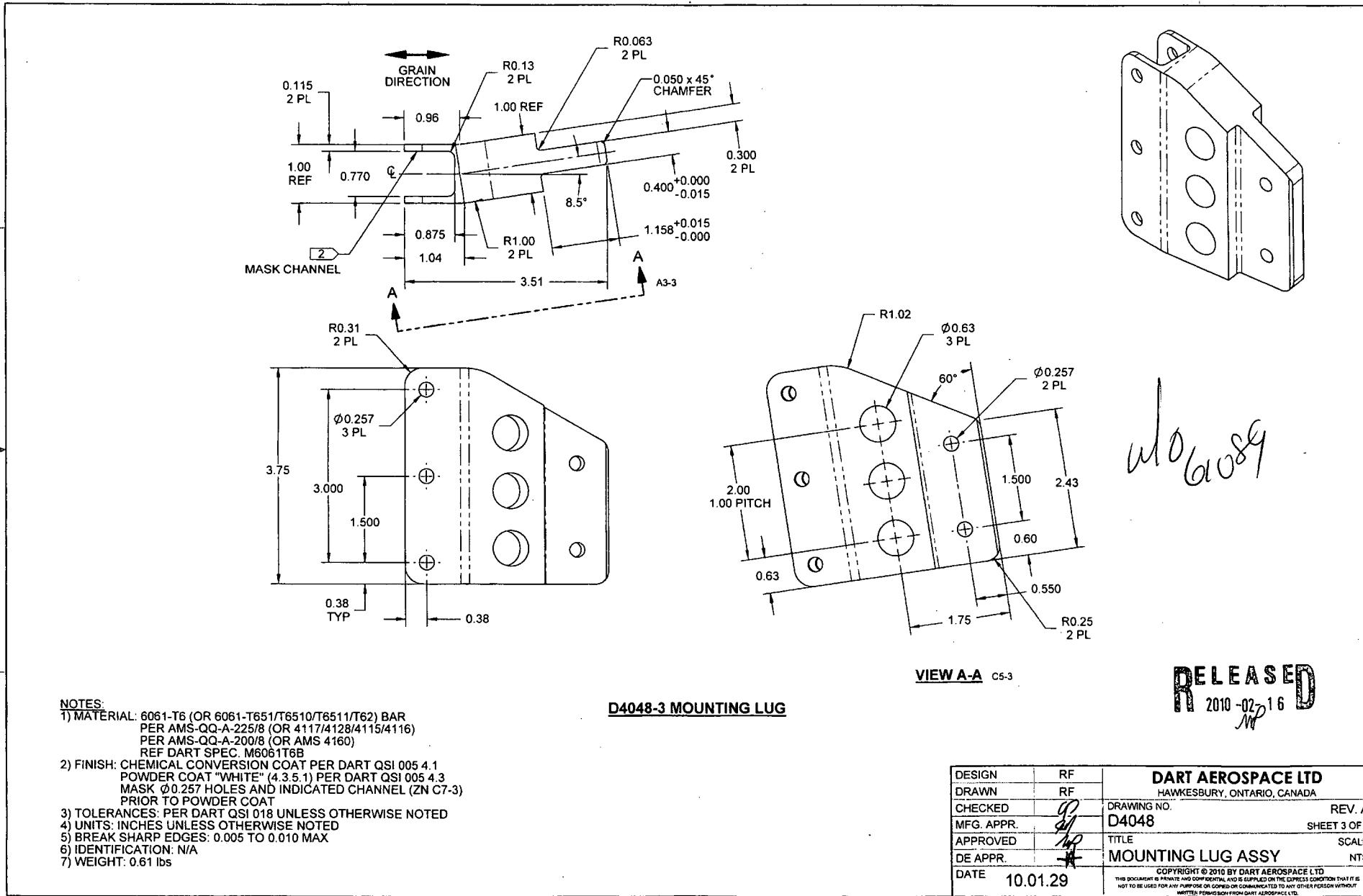
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	X		D4048-041	MOUNTING LUG ASSY
		X	D4048-042	MOUNTING LUG ASSY
1	1	1	D4048-1	MOUNTING LUG
2	1		D4048-3	MOUNTING LUG
3		1	D4048-4	MOUNTING LUG
4	4	4	D4048-9	BUSHING
5	2	2	AN960UD416	WASHER
6	2	2	AN4-14A	BOLT
7	2	2	MS21042L4	NUT

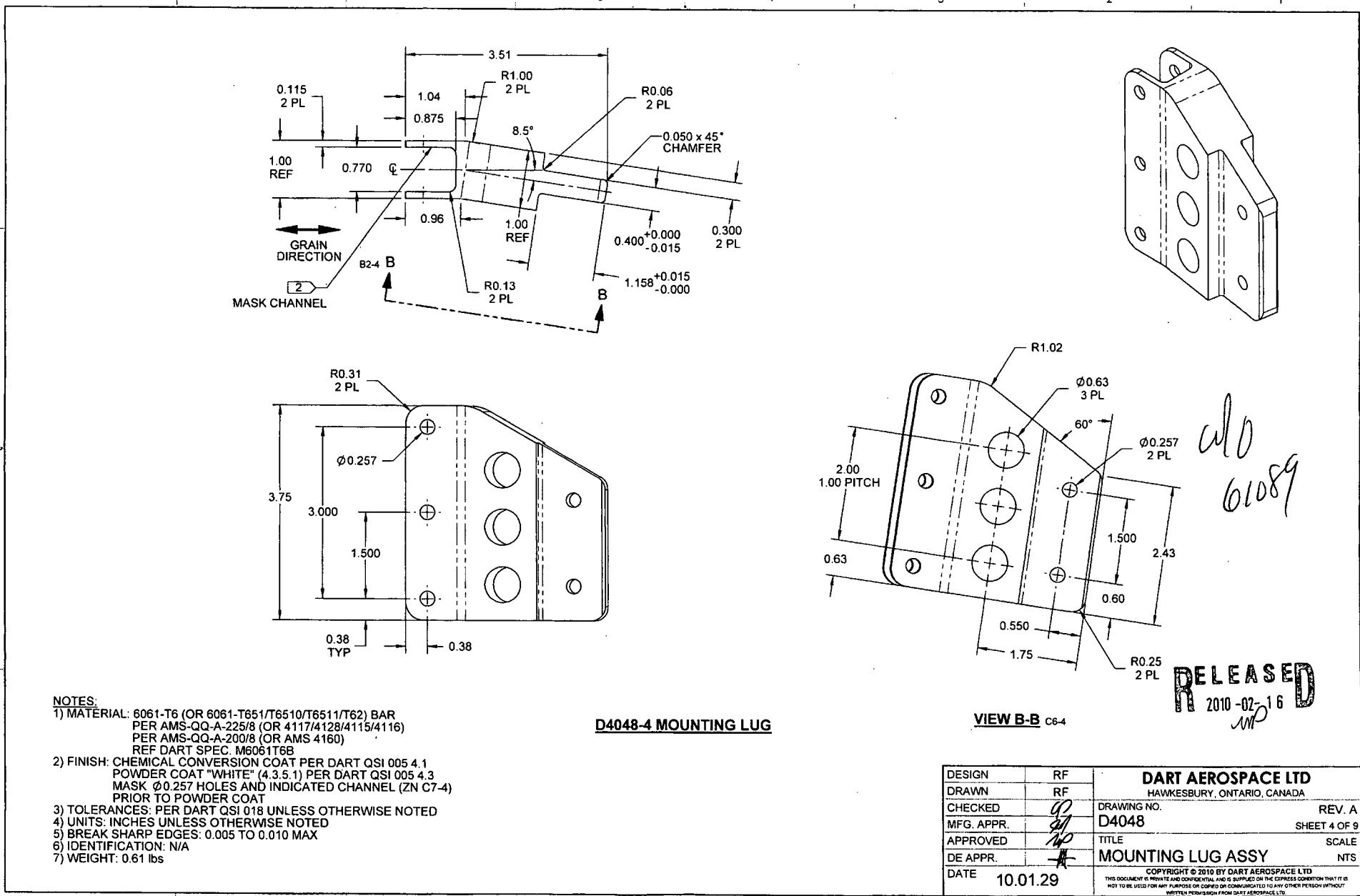
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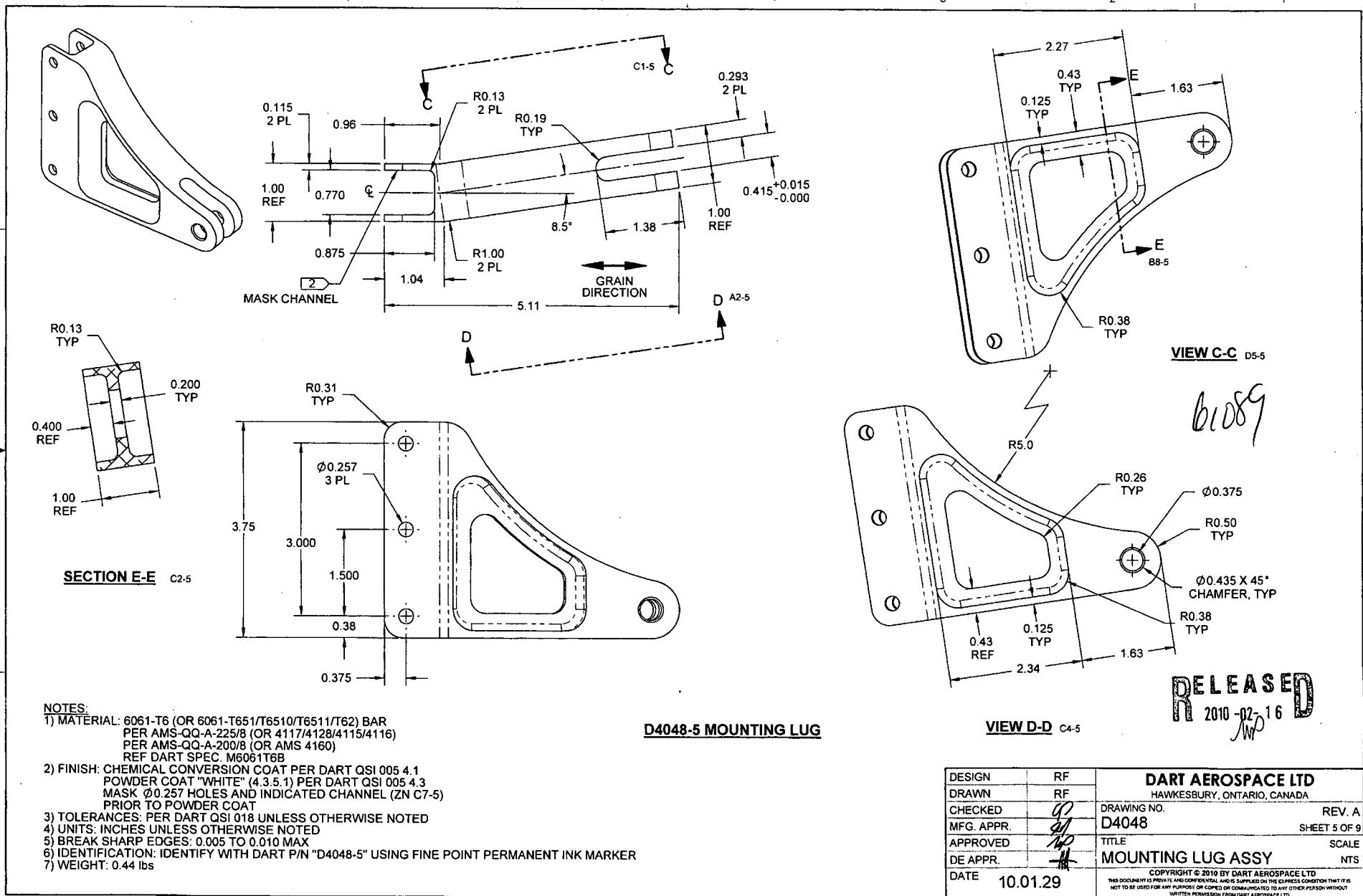
RELEASED 2010-02-16

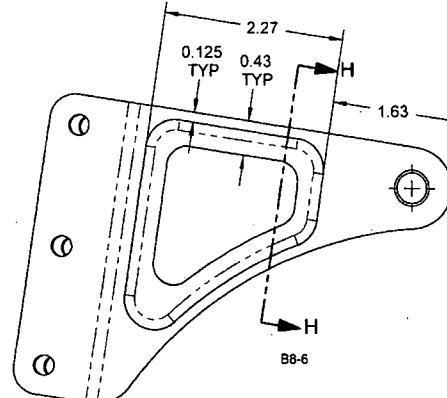
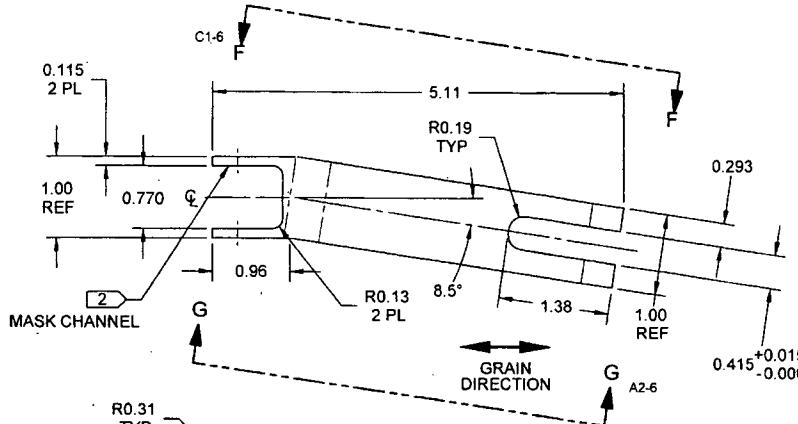
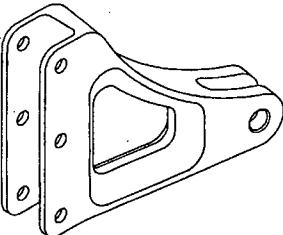
A	NEW ISSUE		RF	10.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b>		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	99	DRAWING NO.	REV. A	
MFG. APPR.	21	D4048	SHEET 1 OF 5	
APPROVED	70	TITLE	SCALE	
DE APPR.	H	MOUNTING LUG ASSY	NTS	
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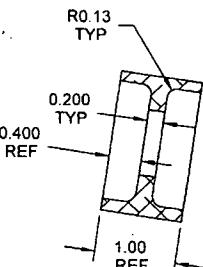




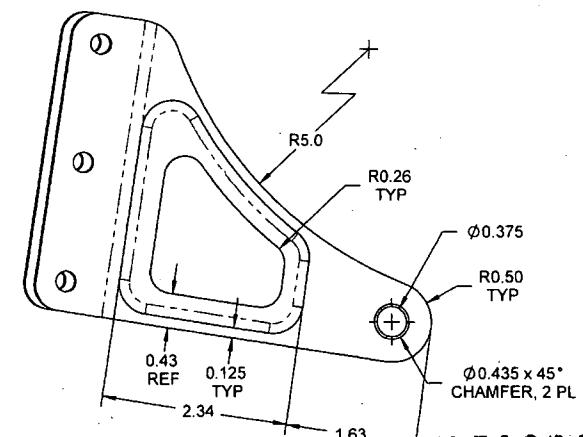
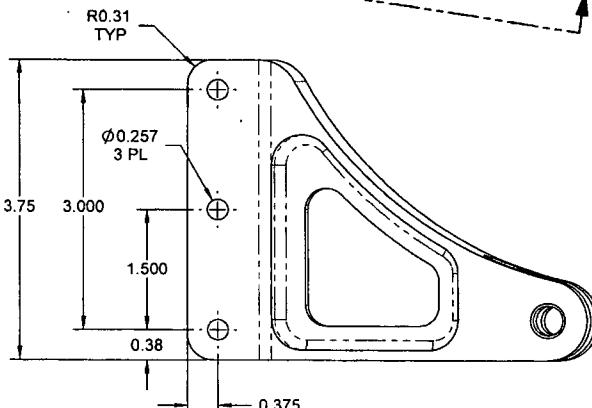




VIEW F-F D6-6



**SECTION H-H C1-6**



10180

RELEASED  
2010-02-16

### D4048-6 MOUNTING LUG

**NOTES:**  
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)

REF DART SPEC. M606176B  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK Ø 0.257 HOLES AND INDICATED CHANNEL (ZN C7-6)  
PRIOR TO POWDER COAT

PRIOR TO POWDER COAT  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

3) TOLERANCES: PER DART QSI U18 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

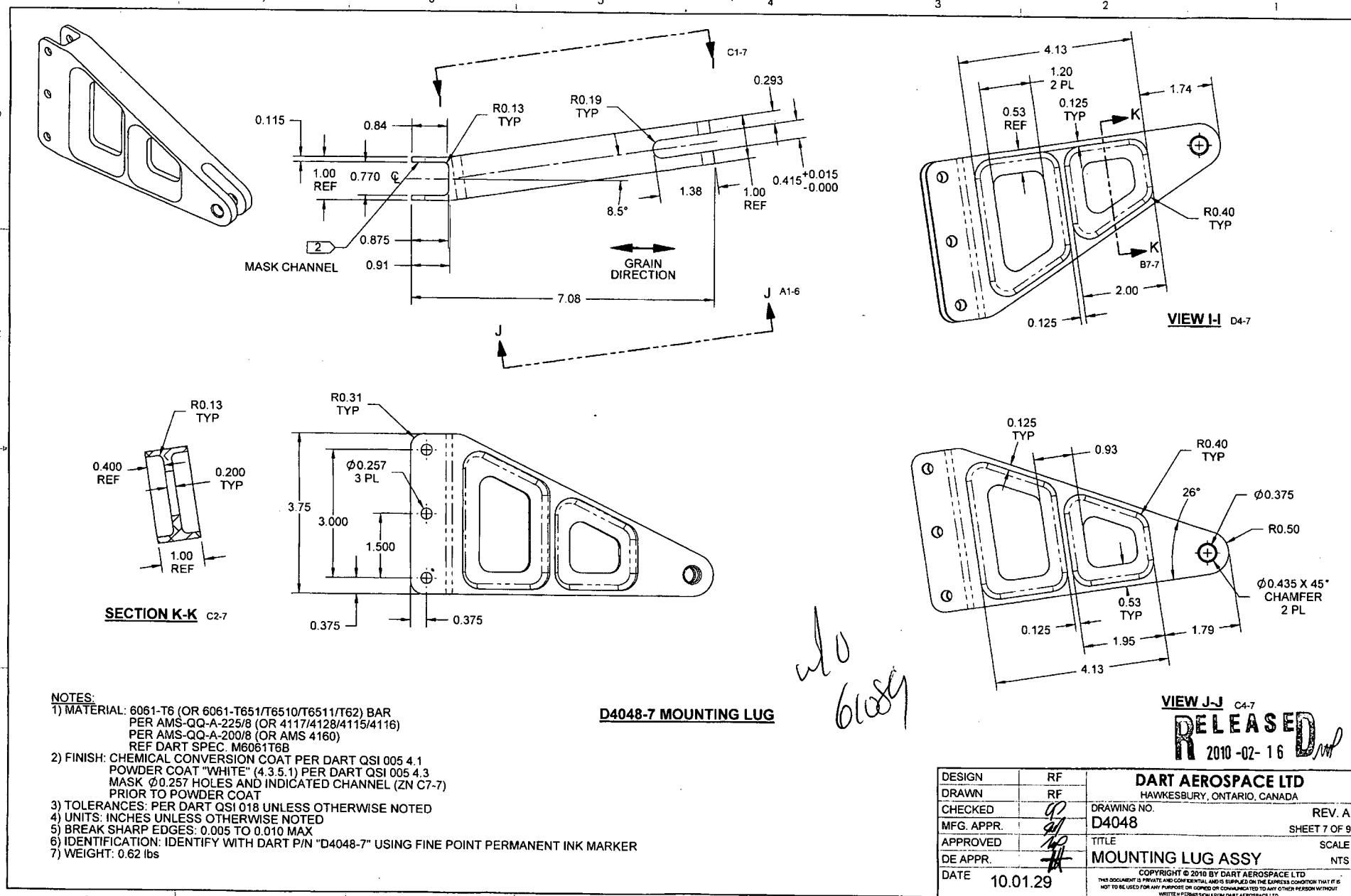
**6) IDENTIFICATION: IDENTIFY WITH PART P/N 1**

9) IDENTIFY WITH BARTENDER B40480 USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.44 lbs

www.3.14153

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	90	DRAWING NO.	REV. A	
MFG. APPR.	90	D4048	SHEET 6 OF 9	
APPROVED	100	TITLE	SCALE	
DE APPR.	100	MOUNTING LUG ASSY		
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## **D4048-7 MOUNTING LUG**

**NOTES:**  
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
PER DART SPEC. MC6061-T6

REF DART SPEC. M6061T6B  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-7  
PRIOR TO POWDER COAT)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

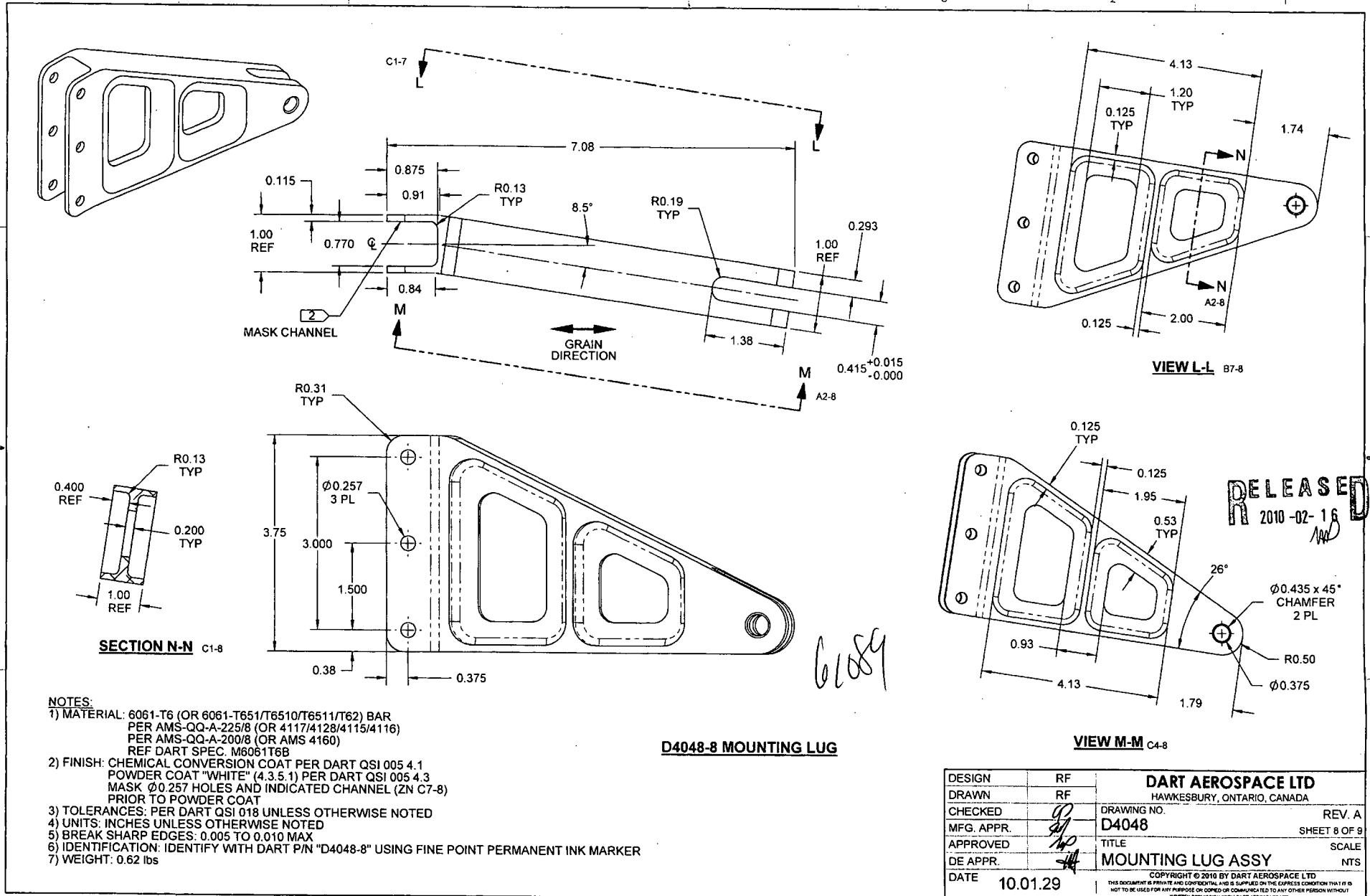
6) IDENTIFICATION: IDENTIFY WITH DART P/N "E"

7) WEIGHT: 0.62 lbs

7) WEIGHT: 0.62 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	99	DRAWING NO.	REV. A	
MFG. APPR.	99	D4048	SHEET 7 OF 9	
APPROVED	99	TITLE	SCALE	
DE APPR.	99	MOUNTING LUG ASSY		
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>90</i>	REV. A
MFG. APPR.	<i>91</i>	SHEET 8 OF 9
APPROVED	<i>90</i>	TITLE
DE APPR.	<i>91</i>	SCALE
DATE	10.01.29	NTS

**MOUNTING LUG ASSY**

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D

D

C

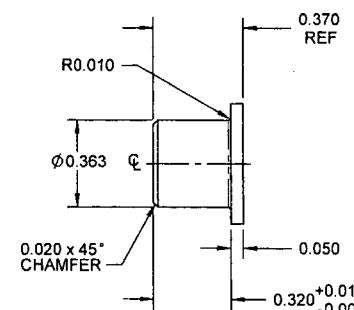
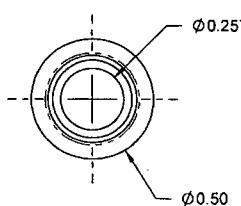
C

B

B

A

A



D4048-9 BUSHING

61089

RELEASED  
2010-02-16  
NP

NOTES:  
1) MATERIAL: AISI 303 STAINLESS STEEL BAR  
REF DART SPEC. M303B

2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	
MFG. APPR.	99	REV. A	
APPROVED	100	D4048	
DE APPR.	100	SHEET 9 OF 9	
DATE	10.01.29	TITLE	
		SCALE	
		MOUNTING LUG ASSY	
		NTS	

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